



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D119-796-141
Job Sheet 176154



Part No: D119-796-141

Job Qty: 1 ea

Part Name: Fwd Crosstube Installation Without Step (No Hardware)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/18/18

Job Tracking No:

Due Date: 4/27/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DRWG D119-795-141 IPP REV:C 14.11.19 AS PER REV:C DD VERF:JLM IPP REV:D 14.12.12 AS PER REV:pd1 DD VERF:JLM IPP REV:E 15.02.11 AS PER REV F JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		4/26/18	0.00	0.00	Start Up Crosstubes-1		GP 17-07-10
130	CNC Bend Crosstubes	1 pcs		4/26/18	0.00	3.85	CNC Bend Crosstube		GP 17-07-10
140	QC	1 pcs		4/26/18	0.00	0.00	QC15		38
145	Crosstubes	1 pcs		4/26/18	0.00	3.06	Crosstubes-1		GP 17-07-16
150	Crosstubes	1 pcs		4/26/18	0.00	3.06	Crosstubes-1		DP 18-08-23
160	HandFXtube	1 pcs		4/26/18	0.00	1.49	HandFinish5		DP 18-08-23
175	QC	1 pcs		4/26/18	0.00	0.00	QC7-1		PD 18-07-23
180	Outsource	1 pcs		4/26/18			SKY002-VC	2	2018 JUL 30 2018
190	Packaging	1 pcs		4/26/18	0.00	0.00	Packaging1-1		2018 JUL 30 2018
200	QC	1 pcs		4/26/18	0.00	0.00	QC5 QCL		9
230	SprayPaint	1 pcs		4/26/18	0.00	1.36	Spray Paint		2018 JUL 30 2018
240	QC	1 pcs		4/26/18	0.00	0.00	QC14		2018 JUL 30 2018
242	Crosstubes	1 pcs		4/26/18	0.00	3.06	Crosstubes-1		2018 AUG 22 2018
244	QC	1 pcs		4/26/18	0.00	0.00	QC5		2018 AUG 22 2018
246	SprayPaint	1 pcs		4/26/18	0.00	1.36	Spray Paint		2018 AUG 22 2018
248	SprayPaint	1 pcs		4/26/18	0.00	1.36	Spray Paint		2018 AUG 22 2018
250	QC	1 pcs		4/26/18	0.00	0.00	QC14		2018 AUG 22 2018
252	Crosstubes	1 pcs		4/27/18	0.00	3.06	Crosstubes-1		2018 AUG 22 2018
260	QC	1 pcs		4/27/18	0.00	0.00	QC5		2018 AUG 22 2018
275	DC	1 pcs		4/27/18	0.00	0.00	DC		N/R
290	Packaging	1 pcs		4/27/18	0.00	0.00	Packaging3-1	LG 050	2018 AUG 22 2018
300	QC21-FG	1 Ea		4/27/18	0.00	0.00	QC21		2018 AUG 23 2018

Part Op 130 - Bend tube as per Dwg D119-796-141 using CNC bender program
 Descriptions: 145 - 1- CUT TUBE AT HEIGHT ON FAI SHEET 2- VERIFY HEIGHT: _____ BY QC15 LEVEL _____
 INSPECTOR: _____ 3- DEBURR CUT SURFACE
 150 - ***** ENSURE PROPER JIG POSITIONING ***** ENSURE PROPER JIG POSITIONING
 ***** 1-DRILL TUBE AS PER DWG USING DT _____ 2- DRILL RIVET HOLES USING DT8787 FWD 3-
 DEBURR AND C'SINK RIVET HOLES AS PER DWG 4- FLIP TUBE, REPEAT STEP 2 AND 3 5- SCRIBE PART# AND
 BATCH# USING VIBRATING STYLUS ON INSIDE OF CUFF AS PER DWG D119-796-141 6- INSPECT AND REMOVE
 ALL MARKS FROM TUBE WITHIN LIMITS ON DWG D119-796-141
 160 - ***IMMEDIATELY AFTER GRINDING*** 1- handfinish X-TUBE INSIDE AND OUT 2- ALODINE AND ACID ETCH X-
 TUBE INSIDE AND OUT AS PER QSI005.
 180 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or

Date: 07/10/18

Issue P/O: 040621 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order

190 - Ensure copy of NDT results attached to work order.

200 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Inspect for damage & ensure results are as per Dwg D119-796-141

230 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O _____ ***MASK SCRIBE B# & P# AND VERIFY*** 1- Prime inside of tube. 2- Install nut plates as per dwg (D2873-043) 3- Mask cuffs per note#2. 4- Prime exterior of tube per QSI005. Primer Batch: 138847 Start Time: _____ Finish Time: _____

240 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____

242 - Assemble as per dwg D119-796-141 and Qsi 015 1- Abrade mating surfaces with Scotch Brite 7447 and clean with Dupont 4105s or equivalent as per dwg. 2- Install D5152-041 with proseal 890 on concave surface, 0.100" MIN thick as per dwg using DT10089 (identified right and left) ****MAINTAIN CLAMPING PRESSURE ON FOR MIN 72HRS*****

Proseal Batch: _____ EXP: _____ PROSEAL CURE TIME 72 HOURS:

Start: _____ Finish: _____ 3- Install support and shim, using proseal 890 per dwg and clamp in position.

244 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____

246 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____ 1- Remove all non-fixed hardware and clean any excess proseal. 2- Scuff tube with Scotch Brite 7447. 3- Mask cuff per note#2. 4- Prime as per dwg and QSI005 5- Apply matte clear as per dwg and QSI005 Clear Batch: 138819 Primer 138847248 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____ 1- Mask underside of tube as per dwg. Mask cuff per note#2. 2- Scuff tube with Scotch Brite 7447 3- Paint outside of crosstube Paint Batch: 138911

250 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____

252 - 1- Re-install non fixed hardware per dwg ***Torque all clamps to 80-100 IN-LBS.*** 2- Apply a filet-seal of proseal 890 around supports. Allow proseal to dry before inspecting. Proseal 890 Batch: _____

EXP: _____ PROSEAL CURE TIME 72 HOURS: Start: _____

Finish: _____

260 - ***RE-CHECK TORCQUE ON CLAMP AFTER PROSEAL HAS CURED AS PER DWG.*** ***VERIFY BY _____ BATCH # TO MATCH W/O _____

275 - Photocopy bluefile and create labels as per PPP D119-796-141 chg 004

290 - Identify and pack for shipping as per PPP D119-796-141

On w/o 177096

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D119-796-141TRN	Crosstube Turning Detail	1 Ea (1 ea)	90-Start up Operation	
CR3212-4-08	Rivet	16 Ea (16 ea)	242-Crosstubes	
D2873-043	Nut Plate Assembly	4 Ea (4 ea)	242-Crosstubes	
D5123-3	Clamp Cushion	4 Ea (4 ea)	242-Crosstubes	
D5124-1	Fwd Support	2 Ea (2 ea)	242-Crosstubes	
D5152-041	Fwd Post Mount Assembly	2 Ea (2 ea)	242-Crosstubes	
D5305-1	Shim	2 Ea (2 ea)	242-Crosstubes	
MS21920-24	Clamp	4 Ea (4 ea)	252-Crosstubes	

Job Allocations

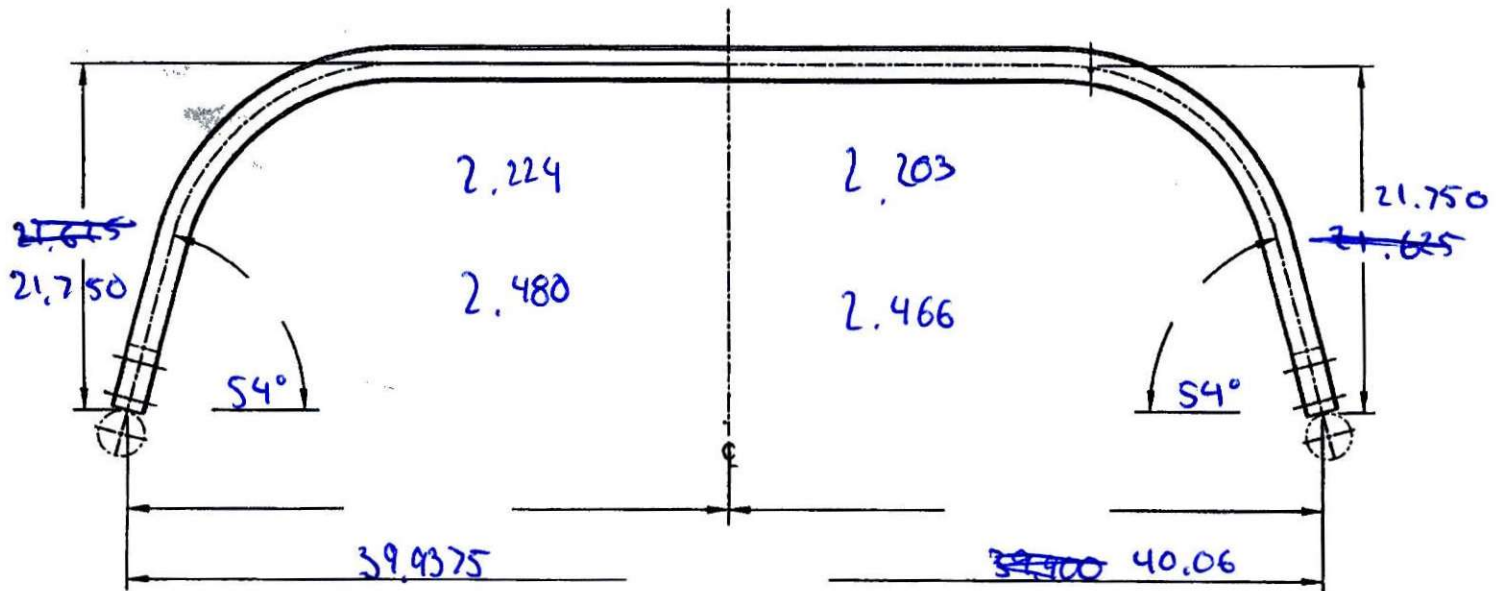
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D119-796-141TRN	1	8	0
242-Crosstubes	CR3212-4-08 <u>5071659</u>	<u>16</u>	180	0
	D2873-043 <u>5089003</u>	<u>4</u>	59	0
	D5123-3 <u>5006028</u>	<u>4</u>	306	0
	D5124-1 <u>5081276</u>	<u>2</u>	6	0
	D5152-041 <u>5083653</u>	<u>2</u>	10	0
	D5305-1 <u>5070880</u>	<u>2</u>	15	0
252-Crosstubes	MS21920-24 <u>5024696x2</u> <u>5034405x2</u>	<u>4</u>	57	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Crosstube Assembly (AW119 MKI Fwd)	6.000Inches ± 0.030	6.030 5.970		
2	Crosstube Assembly (AW119 MKI Fwd)	2.516Inches ± 0.005	2.521 2.511		
3	Crosstube Assembly (AW119 MKI Fwd)	2.333Inches + 0.005 - 0.000	2.338 2.333		
4	Crosstube Assembly (AW119 MKI Fwd)	2.333Inches + 0.005 - 0.000	2.338 2.333		
5	Crosstube Assembly (AW119 MKI Fwd)	2.408Inches + 0.005 - 0.000	2.413 2.408		
6	Crosstube Assembly (AW119 MKI Fwd)	2.502Inches + 0.005 - 0.000	2.507 2.502		
7	Crosstube Assembly (AW119 MKI Fwd)	2.596Inches + 0.005 - 0.000	2.601 2.596		
8	Crosstube Assembly (AW119 MKI Fwd)	2.596Inches + 0.005 - 0.000	2.601 2.596		
9	Crosstube Assembly (AW119 MKI Fwd)	6.000Inches ± 0.030	6.030 5.970		
10	Crosstube Assembly (AW119 MKI Fwd)	2.516Inches ± 0.005	2.521 2.511		
11	Crosstube Assembly (AW119 MKI Fwd)	2.333Inches + 0.005 - 0.000	2.338 2.333		
12	Crosstube Assembly (AW119 MKI Fwd)	2.333Inches + 0.005 - 0.000	2.338 2.333		
13	Crosstube Assembly (AW119 MKI Fwd)	2.408Inches + 0.005 - 0.000	2.413 2.408		
14	Crosstube Assembly (AW119 MKI Fwd)	2.502Inches + 0.005 - 0.000	2.507 2.502		
15	Crosstube Assembly (AW119 MKI Fwd)	2.596Inches + 0.005 - 0.000	2.601 2.596		
16	Crosstube Assembly (AW119 MKI Fwd)	2.596Inches + 0.005 - 0.000	2.601 2.596		
17	Crosstube Assembly (AW119 MKI Fwd)	102.260Inches ± 0.020	102.280 102.240		

Plex 4/18/18 9:53 AM Dart.Gagnon.Michelle

DART AEROSPACE LTD		Work Order:	176154
Description: Crosstube Fwd, with Step		Part Number:	D119-796-141
Inspection Dwg: D119-796-141 Rev: H		Page 1 of 1	

Required Dimension	Min	Max
Height	21.490	21.750
1/2 Span	39.820	40.080
Angle	54°	57°
Total Span	79.640	80.160
Bending Passes	8	--
Crushing	--	6.8%



	Side A	Side B
Bending Passes	11	13
Crushing	5.4%	5.6%
Comments		

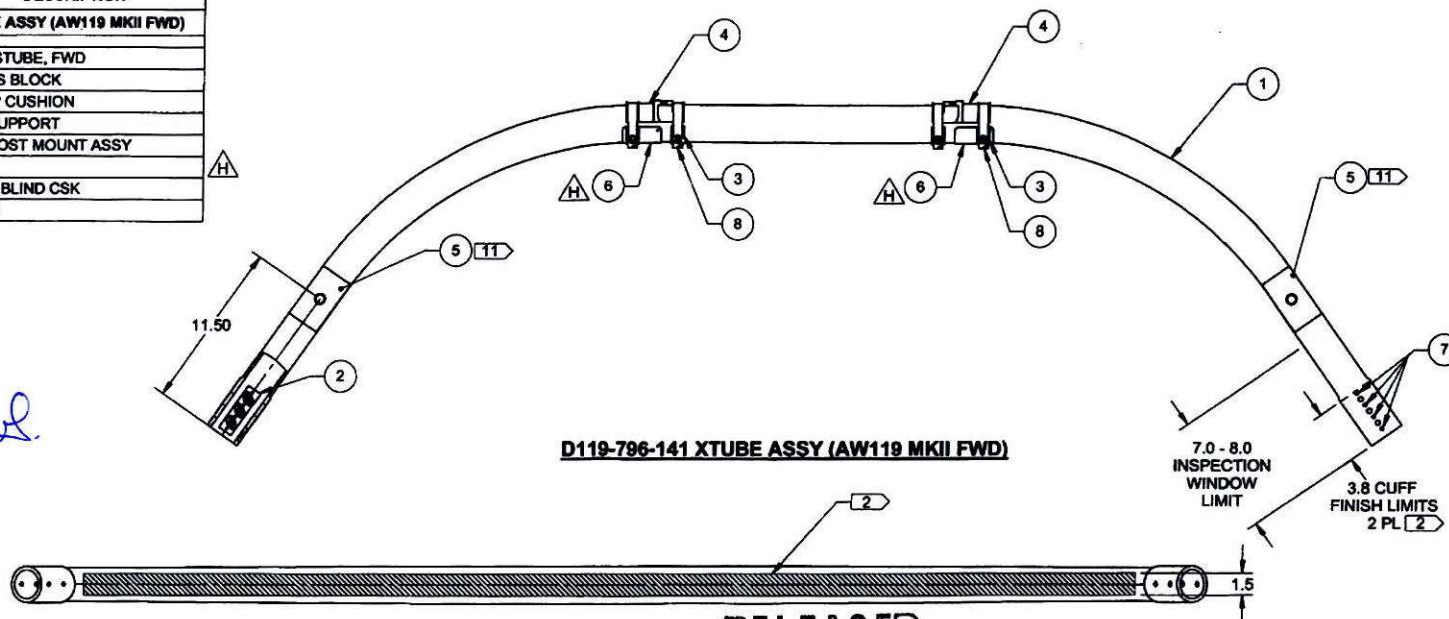
QC15 Inspection	EB
Date	18-07-12

Rev	Date	Change	Revised by	Approved
A	15.04.14	New Issue	KJ	
B	15.11.12	Dwg Rev updated	KJ	
C	16.01.15	Dwg Rev updated	KJ	up

ITEM	QTY	P/N	DESCRIPTION
	X	D119-796-141	XTUBE ASSY (AW119 MKII FWD)
1	1	D119-796-141BND	CROSSTUBE, FWD
2	4	D2873-043	RADIUS BLOCK
3	4	D5123-3	CLAMP CUSHION
4	2	D5124-1	FWD SUPPORT
5	2	D5152-041	FWD POST MOUNT ASSY
6	2	D5305-1	SHIM
7	16	CR3212-4-08	RIVET, BLIND CSK
8	4	MS21920-24	CLAMP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 176154

APR 18 2018



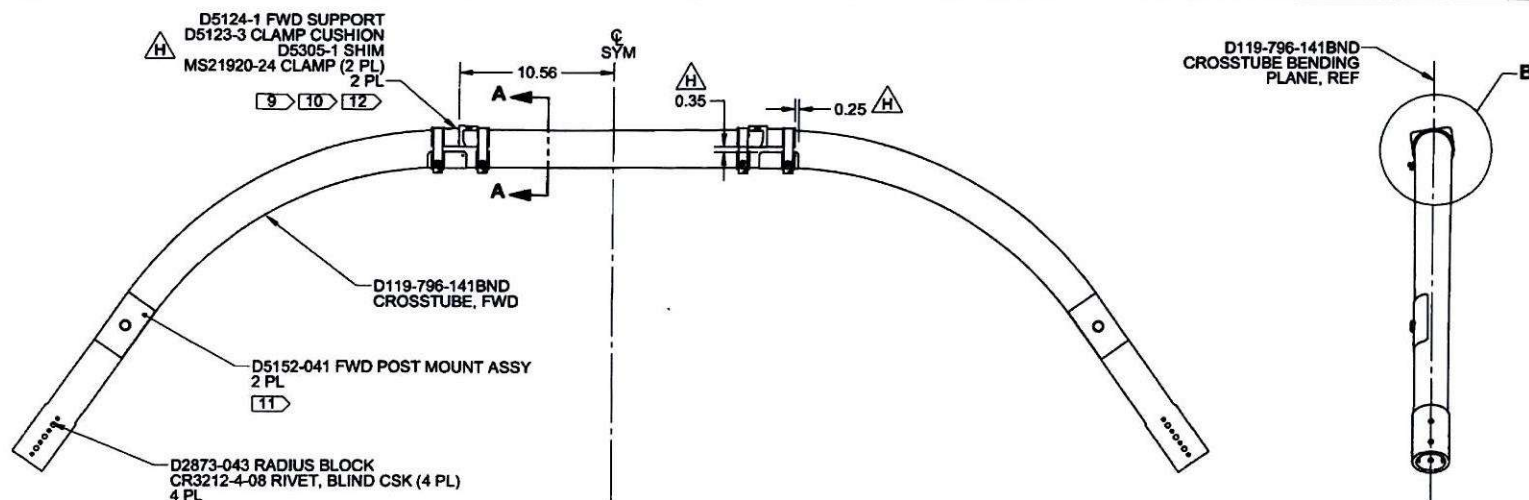
D119-796-141 XTUBE ASSY (AW119 MKII FWD)

RELEASED
2015-11-04
ECN 15-642

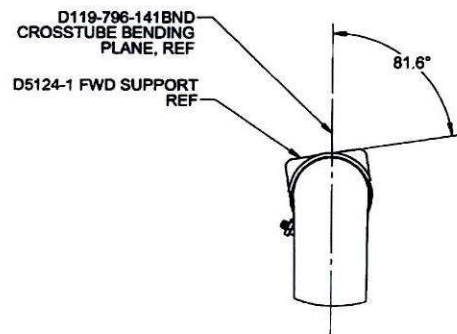
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: APPLY MATTE CLEAR COAT PER QSI 005 4.2
MASK D5124-1 FWD SUPPORTS, D5305-1 SHIMS AS WELL AS UNDERSIDE OF CROSSTUBE AS SHOWN (B3-1, HATCHED AREA),
PAINT OUTSIDE PER DART QSI 005 4.2 AFTER APPLYING CLEAR COAT
DO NOT APPLY FINISH (PAINT OR CLEAR COAT) TO CUFFS IN LOCATION SHOWN, MASK PRIOR TO FINISHING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY USING PART NUMBER "D119-796-141" AND BATCH NUMBER ON INSIDE OF CUFF PER QSI 044 6.4
- 7) WEIGHT: 18.54 lbs
- 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE.
THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM DEFECTS SUCH AS SCRATCHES, NICKS OR DENTS.
DEFECTS UP TO 0.005 MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 9) PRIOR TO FINISHING, ABRASE MATING SURFACES OF D5124-1 FWD SUPPORTS AND CROSSTUBE WITH SCOTCH BRITE 7447 RED AND REMOVE RESIDUE WITH DUPONT 4105S WASH'N'WIPE DEGREASER. APPLY A 0.1 MIN THK LAYER OF PROSEAL 890 ON THE INSIDE CONCAVE SURFACE OF THE D5124-1 FWD SUPPORTS AND INSTALL AT AN 8.4" OFFSET FROM THE CROSSTUBE BENDING PLANE. INSTALL THE MS21920-24 CLAMPS AND D5123-3 CLAMP CUSHIONS WHILE WET.
- 10) TORQUE MS21920 CLAMPS 80 - 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY, THE NUT IS FACING AFT AND HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.
- 11) PRIOR TO FINISHING, ABRASE MATING SURFACES OF CROSSTUBE AND D5152-041 WITH SCOTCH BRITE 7447 RED AND REMOVE RESIDUE WITH DUPONT 4105S WASH'N'WIPE DEGREASER. INSTALL D5152-041 WITH LAYER OF PROSEAL 890 ON INSIDE CONCAVE SURFACE, 0.1 MIN THK. LOCATE D5152-041 USING TOOL DT10089.
- 12) PRIOR TO FINISHING, ABRASE MATING SURFACES OF CROSSTUBE AND D5305-1 SHIM WITH SCOTCH BRITE 7447 RED AND REMOVE RESIDUE WITH DUPONT 4105S WASH'N'WIPE DEGREASER. INSTALL D5305-1 SHIM WITH LAYER OF PROSEAL 890 ON INSIDE CONCAVE SURFACE, 0.1 MIN THK. USE ADDITIONAL TEMPORARY MS21920-24 CLAMP TO APPLY CLAMPING PRESSURE FOR 72 HOURS.

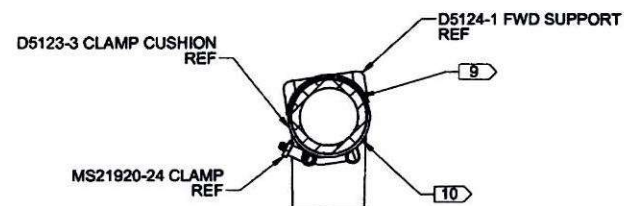
H	ADD D5305-1 SHIM, D6024-103 WAS D6005-103, D5124-1 NOW INSTALLED ON PRIMER	AP	15.10.13
G	FINISHING ORDER ADJUSTED, CR3212-4-08 WAS -07, CUFF DIA TOLERANCE INCREASED TO +0.0005	AP	15.04.24
F	REMOVED PRIME/ PAINT ON CUFFS, 2.518 WAS 2.500 (C8-5)	AP	15.02.03
E	D5152-041 FWD STEP POST ASSY WAS D5150-1 STEP POST, SCOTCH BRITE 7447 RED WAS 180 GRIT SANDPAPER, ANGLE (87-2) DIMENSIONED FROM NEW DATUM	DB	15.01.15
D	ADD D5150-1 STEP POST (2X), MOVED INSPECTION WINDOW DETAIL TO SHEET 1, MODIFIED NOTES ON SHIT 1 & 3	DB	14.11.25
C	CR3212-4-07 RIVETS WERE CR3212-4-09, 7.5 DEG CUFF ANGLE OFFSET REMOVED (SHIT 3), CUFF DIAMETER ON D119-796-141TRN REDUCED TO 2.500, ADDED INSPECTION WINDOW (B7-3), ADDED SHIT 4	AP	14.10.23
B	ADDED D2873-043 RADIUS BLOCK, CR3212-4-09 RIVETS, ADDED SKIDTUBE REFERENCE FOR LOCATING CUFF HOLES, RE-ORGANIZED NOTES AND REMOVED REDUNDANT INFORMATION	AP	14.09.02
A	NEW ISSUE	AP	14.08.09
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D119-796-141 REV. H SHEET 1 OF 6 SCALE XTUBE ASSY (AW119 MKII FWD) NTS COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	AP		
CHECKED	AJS		
MFG. APPR.	JLM		
APPROVED	WM		
DE APPR.	DS	DATE 15.10.13	



D119-796-141 XTUBE ASSY (AW119 MKII FWD)



DETAIL B
SCALE 2X

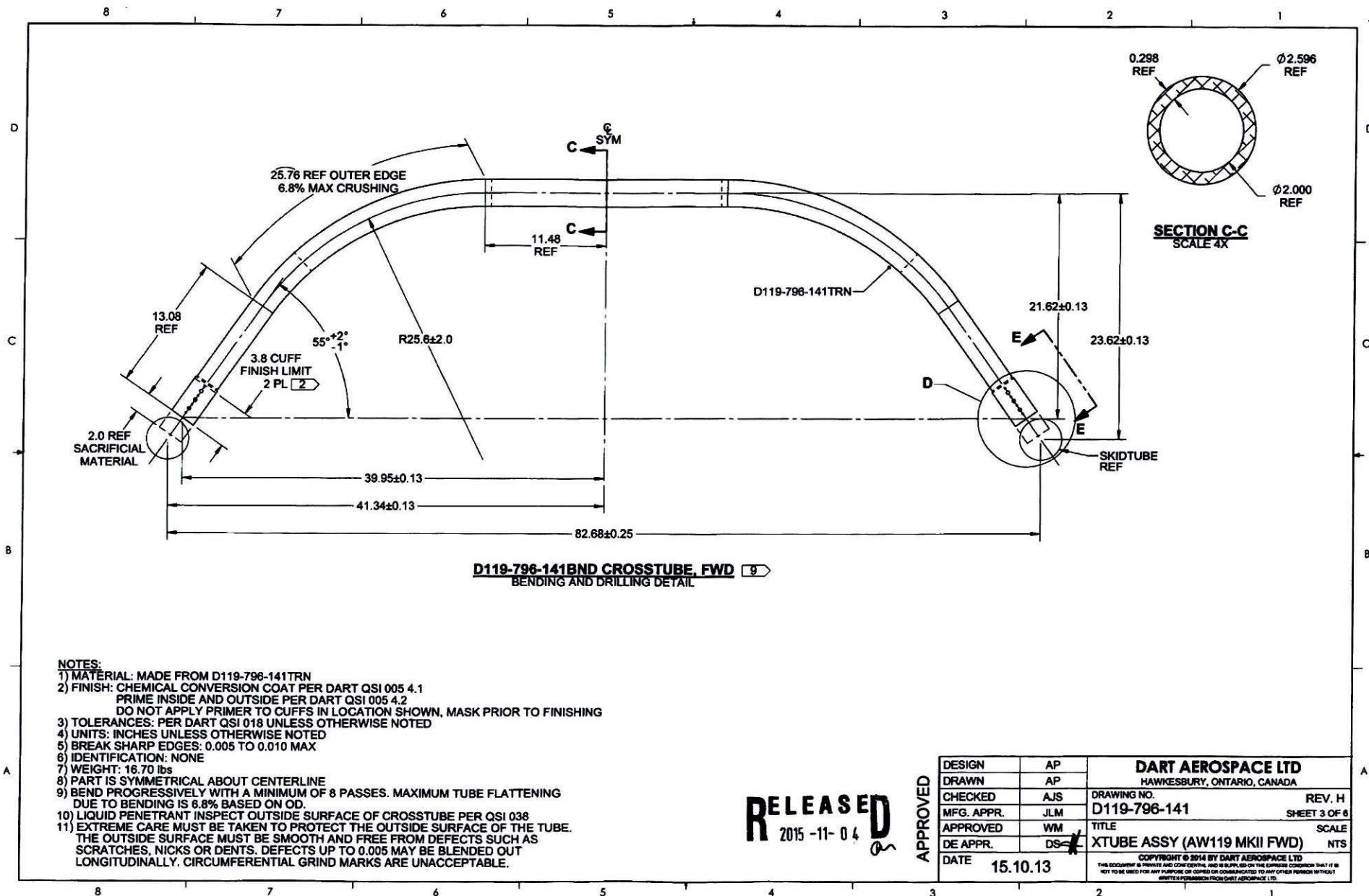


SECTION A-A
SCALE 2X

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2015-11-04

APPROVED

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO.	REV. H
MFG. APPR.	JLM	D119-796-141	SHEET 2 OF 6
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	XTUBE ASSY (AW119 MKII FWD)	NTS
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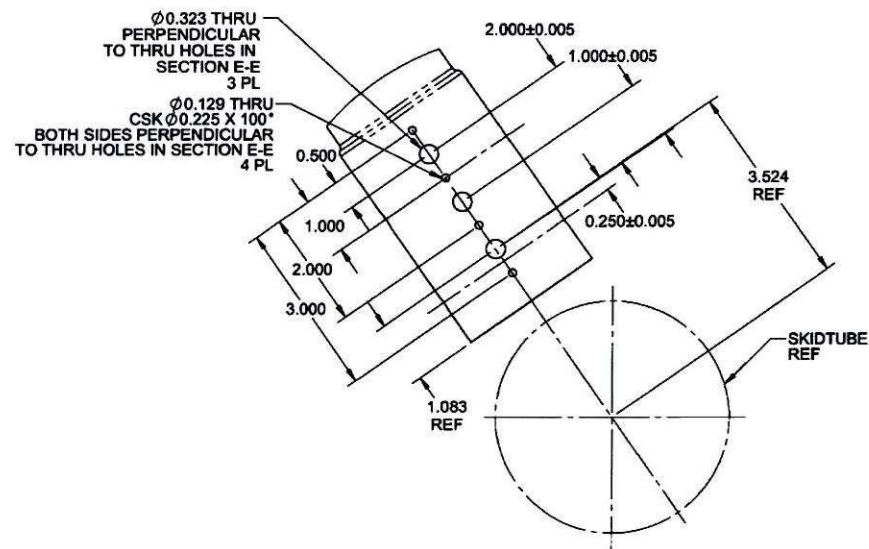
8 7 6 5 4 3 2 1

D

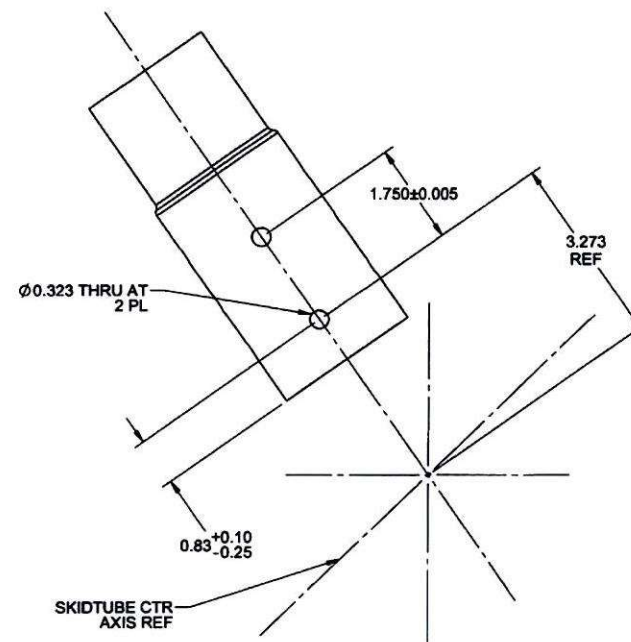
C

B

A



VIEW D
SCALE 4X



VIEW E-E
SCALE 2X

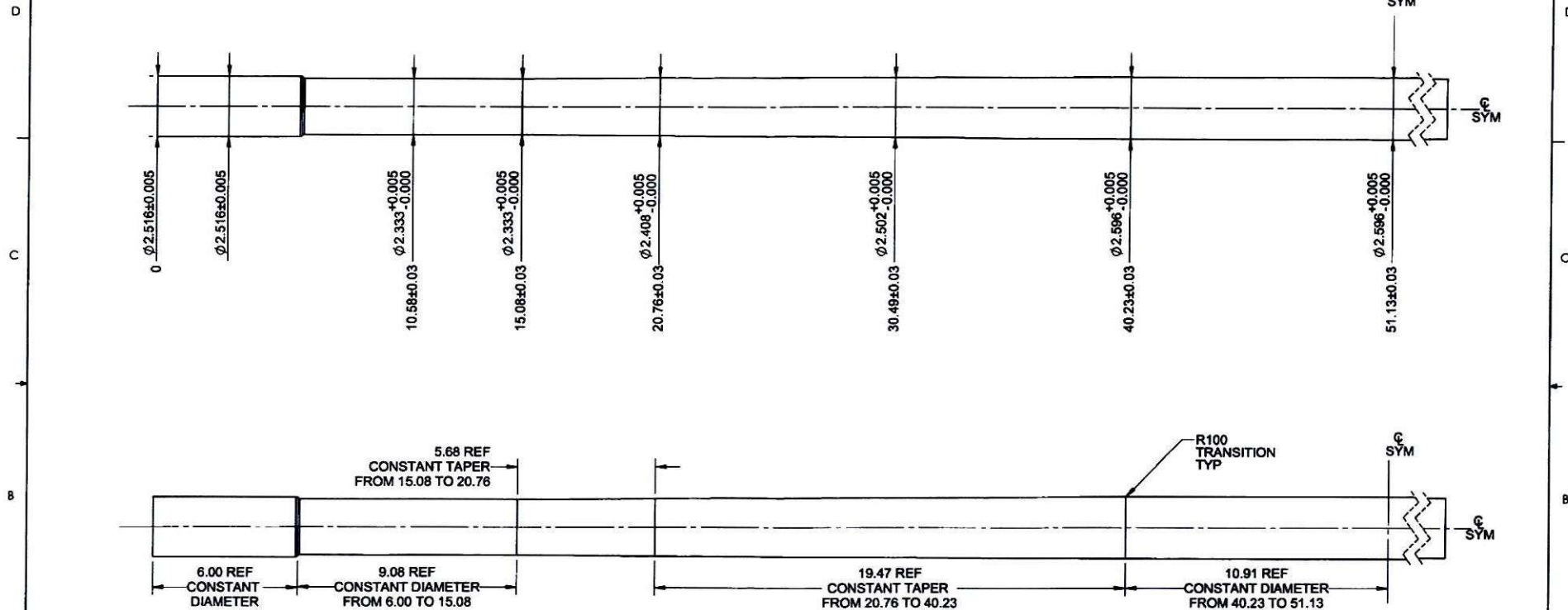
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2015-11-04

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DESIGN	AP	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. H
MFG. APPR.	JLM	D119-796-141	SHEET 4 OF 6
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	XTUBE ASSY (AW119 MKII FWD)	NTS
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



D119-796-141TRN CROSSTUBE, FWD

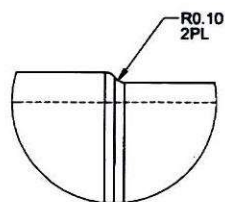
- NOTES:**
- 1) MATERIAL: MANUFACTURE FROM D6024-103 (PREFERRED) OR D6005-103
FINISHED LENGTH = 102.26 ± 0.020 (BEFORE BENDING/TRIMMING)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 16.70 lbs
 - 8) PART IS SYMMETRICAL ABOUT CENTERLINE

RELEASED
2015-11-04

APPROVED

DESIGN	AP	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. H
MFG. APPR.	JLM	D119-796-141	SHEET 5 OF 6
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	XTUBE ASSY (AW119 MKII FWD)	NTS
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D119-796-141TRN CROSSTUBE, FWD
SUPPLEMENTAL VIEW: NOMINAL WALL THICKNESS



DETAIL F
SCALE 2X

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO.	REV. H
MFG. APPR.	JLM	D119-796-141	SHEET 6 OF 6
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	XTUBE ASSY (AW119 MKII FWD)	NTS
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RELEASED
2015-11-04

APPROVED

CHAMFER ID
AS REQUIRED
FOR TOOLING

F

C
SYM

C
SYM

0.258 REF
NOMINAL WALL

0.167 REF
NOMINAL WALL
10.58±0.03

0.167 REF
NOMINAL WALL
15.08±0.03

0.204 REF
NOMINAL WALL
20.78±0.03

0.251 REF
NOMINAL WALL
30.49±0.03

0.298 REF
NOMINAL WALL
40.23±0.03

0.298 REF
NOMINAL WALL
51.13±0.03

**skyservice****Work Order Traveler**
Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO36847	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO040624
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT (LIQUID PENETRANT CRACK TEST) ON THE FOLLOWING HEIGH (8)
CROSSTUBES AND ON ONE ELECTRIC SWIVEL:

P/N: D119-796-141 FWD CROSSTUBE

1- JOB SHEET# 176152 2- JOB SHEET# 176153
3- JOB SHEET# 176154 4- JOB SHEET# 176155

P/N: D135-1027-151 FWD CROSSTUBE

5- JOB SHEET# 179786 6- JOB SHEET# 179787

P/N: D135-1027-251 AFT CROSSTUBE

7- JOB SHEET# 169663 8- JOB SHEET# 169675

P/N: SWA10A-2-OH ELECTRIC SWIVEL

9- JOB SHEET# 178582

1125.00 125.00

Action Taken:	Date:	Initial/Stamp:				
LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE (ITEMS 1-9) AS PER ASTM1417M-16 NO CRACK FOUND. PEN.(ZL-56, MPO13600), DEV.(SKD-S2, MPO11715), CLEANER(SKC-S, MPO MPO19368)	27 JUL 2018	 CS				
Description	Location	P/N	Qty	Batch	S/N Off	S/N On

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp 	Date: 27 JUL 2018
Name: CHRISTIAN BRIEN		



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO040624

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040624
PO Date: 7/27/18
Due Date: 7/31/18
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com

Via: Ground
Pynt Terms: Net 30
Freight Terms:

Special Comments: SWA10A-2-OH - 1 pc - job # 178582 for
rework included in total cost of \$1125.00

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	176152	D119-796-141	Fwd Crosstube Installation Without Step (No Hardware) : TC STC SH14-45-Issue 1, FAA STC SR03504NY 15/01/28, EASA STC 10052022 Revision 1 15/02/13, DGCA INDIA LoA 07-09/2011-AED (Part) 15/07/16, BRAZIL STC 2015S07-16 15/07/30, CAAP PHILIPPINES LoA 16/05/11, CHINA VSTC0757 16/07/22, RUSSIA STC CT316-A119 16/08/11, DGAC INDONESIA STC SR025 18/02/19 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	7/31/18	1 pcs	0 pcs	1 pcs	\$140.625/pcs	\$140.63
	176153			Firmed	-	7/31/18	1 pcs	0 pcs	1 pcs	\$140.625/pcs	\$140.63
	176154			Firmed	-	7/31/18	1 pcs	0 pcs	1 pcs	\$140.625/pcs	\$140.63
	176155			Firmed	-	7/31/18	1 pcs	0 pcs	1 pcs	\$140.625/pcs	\$140.63
Sub Total:							4	0	4		\$562.50
2	179786	D135-1027-151	Std Height Fwd Crosstube ISSUE P/O: _____ C OF C IS REQUIRED	Firmed	-	7/31/18	1 pcs	0 pcs	1 pcs	\$140.625/pcs	\$140.63
	179787			Firmed	-	7/31/18	1 pcs	0 pcs	1 pcs	\$140.625/pcs	\$140.63
Sub Total:							2	0	2		\$281.25



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PURCHASE ORDER

PO040624

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	169663	D135-1027-251	Std Height Aft Crosstube ISSUE P/O: _____ C OF C IS REQUIRED	Firmed	-	7/31/18	1 pcs	0 pcs	1 pcs	\$140.625/pcs	\$140.63
	169675			Firmed	-	7/31/18	1 pcs	0 pcs	1 pcs	\$140.625/pcs	\$140.63
Sub Total:							2	0	2		\$281.25

Grand Total: \$1,125.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/30/18 3:27 PM dart.baker.diane